

Date: Monday, 3/19/2007 8:12:52 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 31254		
Estimate Number	: 10299		
P.O. Number	: N/A	Part Number	: D25775
This Issue	: 3/19/2007 S.O. No. : N/A	Drawing Number	: D2577 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: M/A Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 30879	Material	: N/A
Written By	:	Due Date	: 4/4/2007 Qty: 50 Um: Each
Checked & Approved By	: <u>[Signature] 07.03.19</u>		
Comment	: Est: F 02.09.24 Re-format KJ/RF		
	: Est Rev:D Now on Waterjet 06-06-14 JLM		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S16GA	1010/1025/A21/6aA SHEET	
Comment: Qty.: 1.0301 sf(s)/Unit Total : 51.5025 sf(s) 1010/1025 16GA SHEET (m1010s16ga) Batch: <u>M103840 (23)</u> <u>M103788 (14)</u> <u>M103434 (13)</u> <u>300 07/04/08</u> <u>(2)</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D2577 Dwg Rev: <u>E</u> Prog Rev: <u>E</u> 2-Deburr if necessary		<u>Jm 07/04/09</u> <u>(50)</u> <u>SAD 07/04/08</u> <u>50</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-5T1		<u>SAD 07/04/08</u> <u>50</u>	
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK		<u>En 07/04/09</u> <u>50</u>	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr		<u>SAD 07/04/09</u> <u>(50)</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/04/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:12:52 AM
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Drawing Name: WEARPLATE

Job Number: 31254

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

MF.

07-04-10.

MF

07-04-10

(50)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20704.11

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005.4.3

FR

07/04/11

(50)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

07/04/11

(50X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP18

MF

07/04/11

(50X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/11

(50)

Job Completion



U 20704.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

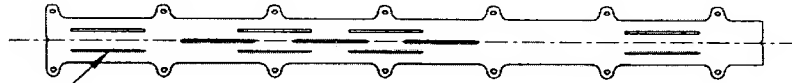
NOTE: Date & initial all entries



RELEASED
00 09 22 11

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE		TITLE	SCALE
00.09.22		WEARSHOE	1:10
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

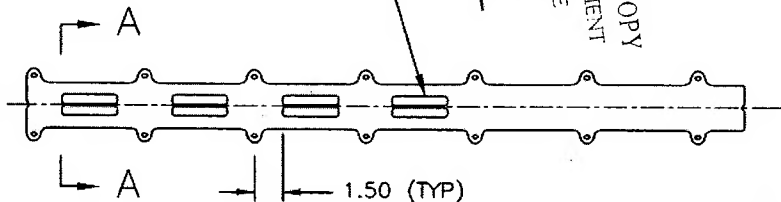
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



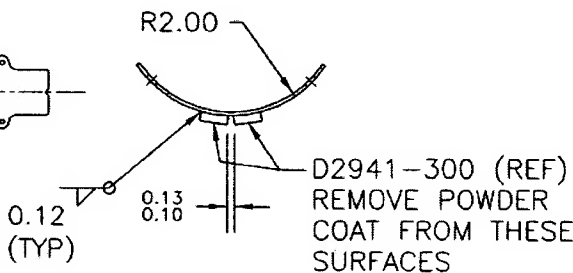
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 31254

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5



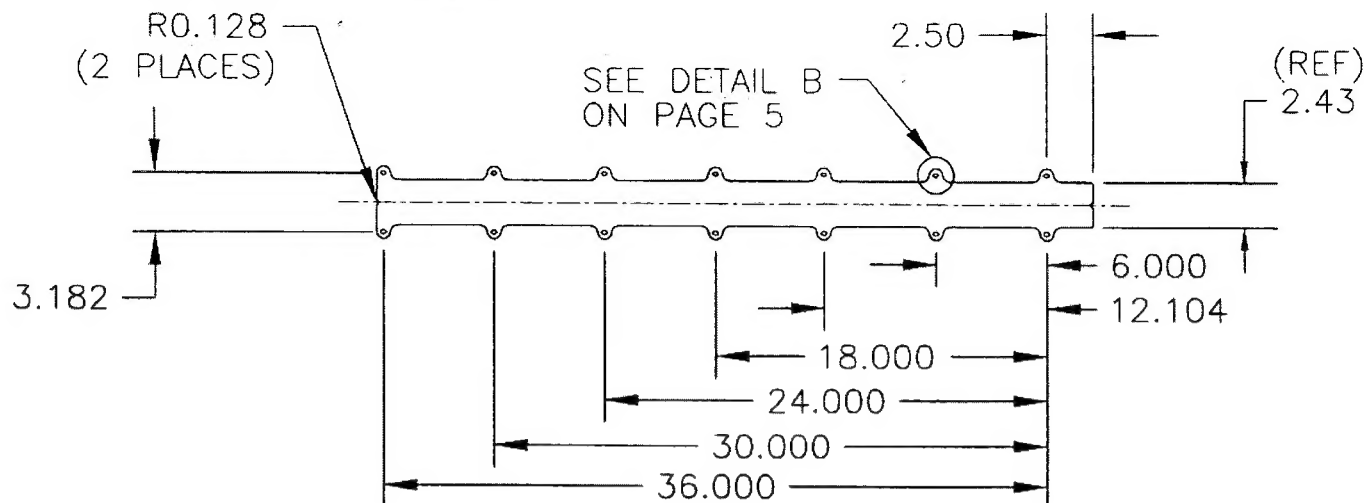
D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DRAWING NO.	REV. E
		D2577	SHEET 2 OF 5
CHECKED 	APPROVED 	TITLE WEARSHOE	SCALE 1:10
DATE 00.09.22			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

RELEASED
00.09.26 #



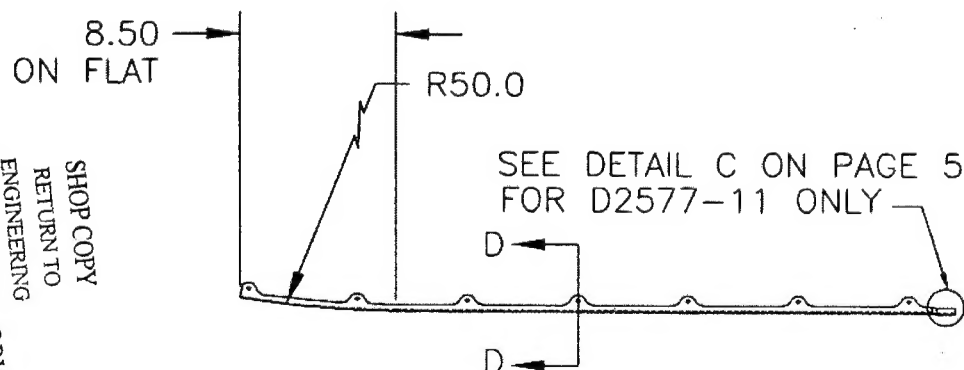
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

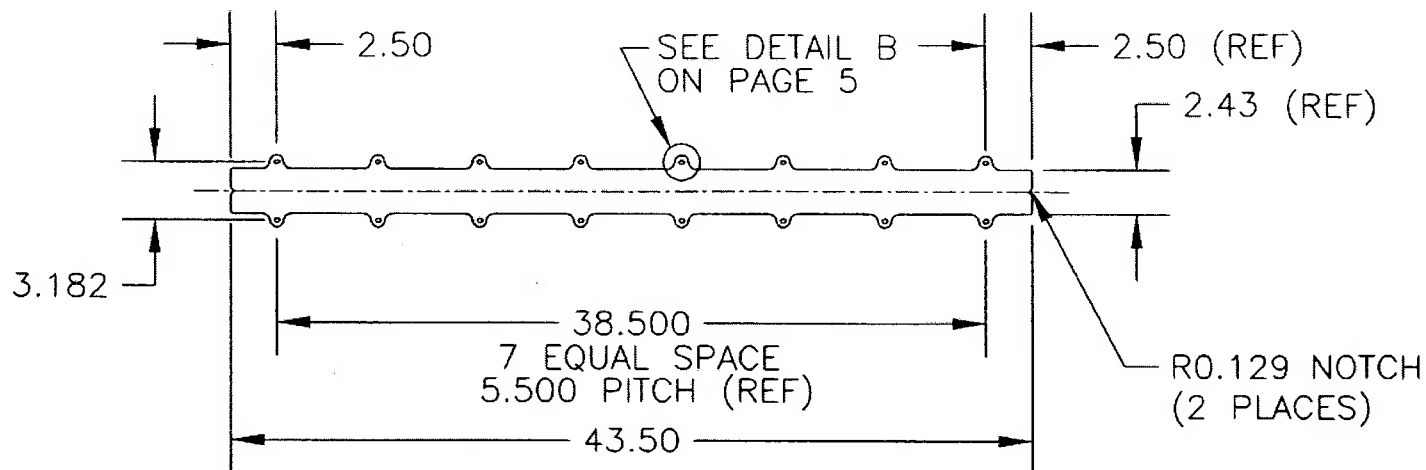
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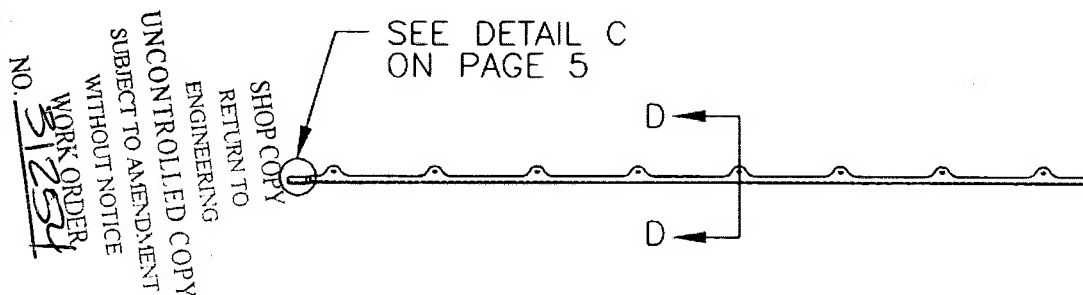
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CHECKED	APPROVED	DRAWING NO. D2577	SHEET 3 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	

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00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

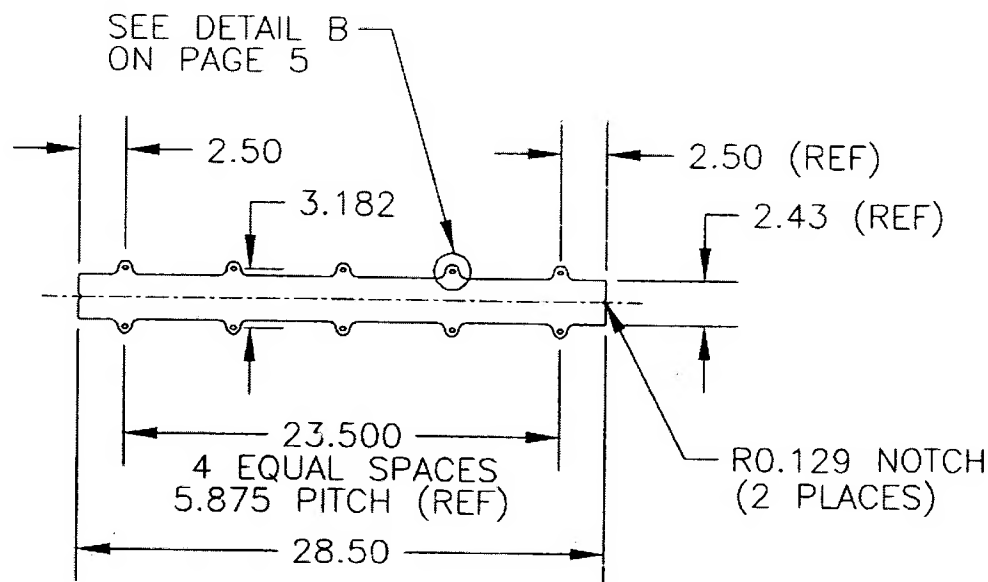
DART



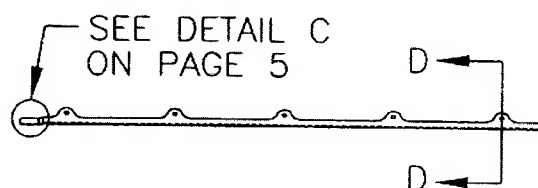
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2577
DATE 00.09.22		TITLE WEARSHOE
		REV. E
		SHEET 4 OF 5
		SCALE 1:10

RELEASED
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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WORK ORDER
NO. 31257

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

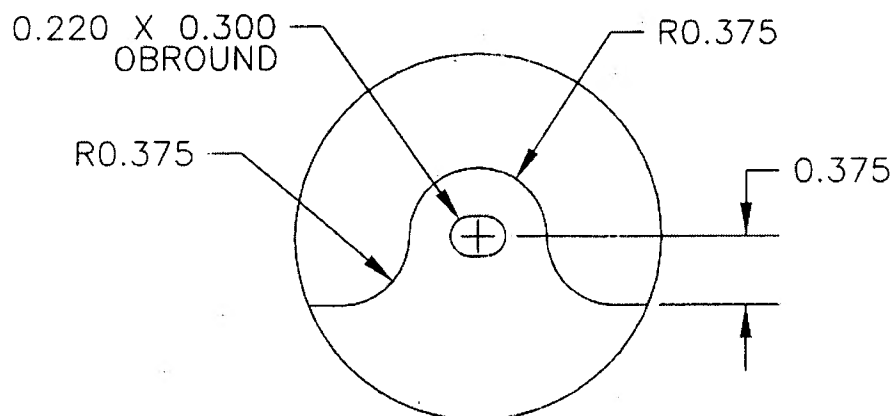
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



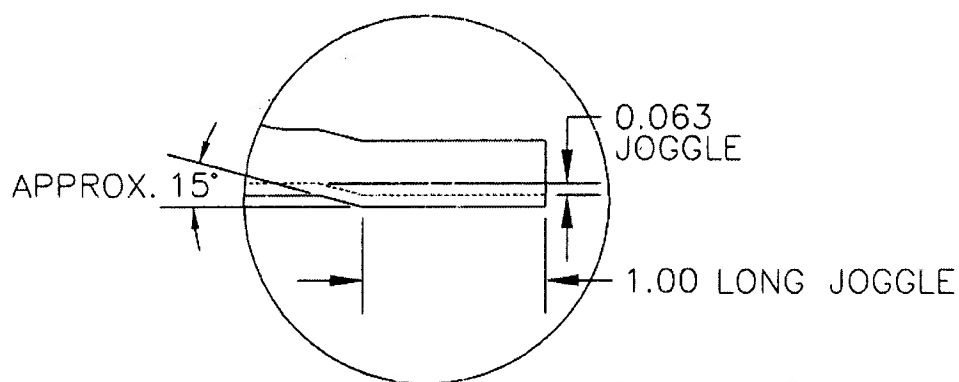
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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

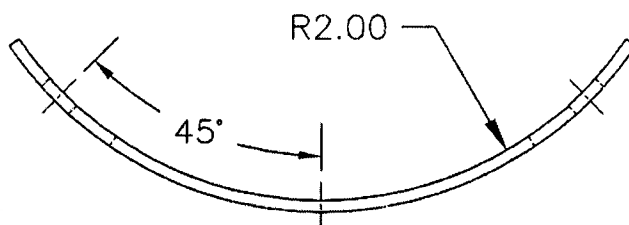
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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